

April 21, 2016 2:06:25 PM

Page 1

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

8

g

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3811 Rev A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 23.250 " long

110

0.88

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

5.60

HAAS CNC vertical machine #1

1- Mill as per Folio FA776Rev: AA & Dwg D3811 Rev: A
2-Deburr per dwg D3808

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.08

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																														
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Work Order ID 144596

April 21, 2016 2:06:25 PM

144596

Page 2

Item ID: D3811-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Seat Track
 Start Date: 4/26/2016 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 5/9/2016 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	CONVENTIONAL MILLING MACHINE					7	1		J.C.L. 16-05-08
Mill Conv	Memo	2.24							
Conventional Milling Machine	1-DRILL REMAINIG HOLES								
140		0.00							
140	QC2- Inspect parts off machine FAI/FAIB					7	1		J.C.L. 16-05-08
QC	Memo	0.08							
Quality Control									
150		0.00							
150	QC8- Inspect parts - second check					7	0		DAS 08 9-89
QC	Memo	0.16							
Quality Control									

P.T.O.

B.a 16/05/08

DQA:

Date: 16.05.27



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: ~~16/05/16~~

Date: 16/05/16

Work Order update only ☐

Work Order: <u>144 596</u> Part No. <u>D3811-1</u> NCR No. <u>16-5781</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																									
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Date: <u>16-05-05</u>	Step #: <u>130</u>	QTY Effective: <u>1</u>		MRB (QSI042) Approval DAS 9 9-89 <u>16.05.05</u>																																									
Description Work Order Deviation			Disposition																																										
One of the $\varnothing 0.323$ hole is drilled at 1.240" from the edge and should be at 1.080" RC operator			Scrap destroy.																																										
			Completed By J.C. - L. 16-05-05																																										
			Lead hand / Supervisor Approval Verification DAS 14 9-89 <u>16/05/05</u>																																										
			QC / QA Coordinator Approval DAS 9 9-89 <u>16-05-05</u>																																										
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Work Order ID 144596

April 21, 2016 2:06:25 PM

144596

Page 3

Item ID: D3811-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Seat Track

Start Date: 4/26/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/9/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

1.04

Hand Finishing

7 x 4 11/16/11

165

QC7-Inspect Chemical Conversion Coat

0.00

165

QC

Memo

0.08

Quality Control

(2) DAS 38 9-89 MAY 12 2016

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.08

Packaging

LOCATION : GA

7 DAS 6 9-89 MAY 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Page 4

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

0.00

0.80

Quality Control

SH 20160513

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

April 21, 2016 2:06:24 PM

Page 1

Work Order ID: 144596

144596

Parent Item: D3811-1

D3811-1

Parent Item Name: Seat Track

Start Date: 4/26/2016

Required Date: 5/9/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 08-07-31 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.50 / 0		Purchased	No			100	f	19.4370	2	16.84211			

M6061T6B1 500X02 500

6061-T6 Bar 1.50 x 2.50

16.000'

DAS
20
9-89

16-04-24

Location

Loc Qty

Loc Code

MAT004

19.437

m133587

0.77

m133828

0.5

m134058 /

18.167

16.000'

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				
								Completed By
								Lead hand / Supervisor Approval Verification
								QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐						
OTHER : ☐								

DART AEROSPACE LTD		Work Order:	144596
Description: Seat Track		Part Number:	D3811-1
Inspection Dwg: D3811	Rev: A	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.40	+/-0.030	.3985	✓		SLIO	View
6.70	+/-0.030	6.700	✓			
0.700	+/-0.010	.700	✓			
1.400	+/-0.010	.1400	✓			
0.990	+/-0.010	.988	✓			
Ø0.281 x 0.44 deep	+0.006/-0.001 x +/-0.030	.282 x .440	✓			
0.780	+/-0.010	.780	✓			
6.48	+/-0.030	6.480	✓			
Ø0.196	+0.005/-0.001	.197	✓			
Ø0.388 x 100°	+0.006/-0.001 x 0.5°	.392 x 100°	✓			
R0.13	+/-0.030	.130	✓		Rad gauge	
0.70	+/-0.030	.700	✓			
6.44	+/-0.030	6.440	✓			
R1.00	+/-0.030	R1.000	✓		Rad gauge	
1.576	+/-0.010	1.576	✓			
1.76	+/-0.030	1.761	✓			
10.00	+/-0.030	10.000	✓			
0.590 pitch	+/-0.010	.590	✓			
0.788 pitch	+/-0.010	.788	✓			
23.00	+/-0.030	23.000	✓			
Ø0.323	+0.006/-0.001	0.323	✓		Caliper	JCL-08
0.27	+/-0.030	0.268	✓			
1.08	+/-0.030	1.080	✓			
20.68	+/-0.030	20.68	✓		Tape	
0.44	+/-0.030	.4415	✓		SLIO	View
1.24	+/-0.030	1.240	✓		Caliper	JCL-08
0.286 x 60°	+/-0.010 x 0.5°	.286 x 60°	✓		SLIO	View
Ø0.388 x 100°	+0.006/-0.001 x 0.5°	.392 x 100°	✓			
R0.032	+/-0.010	.032	✓			
0.132	+/-0.010	.130	✓			
0.315	+/-0.010	.315	✓			
0.015 x 30°	+/-0.010 x 0.5°	.012 x 30°	✓			
0.100	+0.030/-0.010	.107	✓			
1.98	+/-0.030	1.978	✓			

Manual Mill

DART AEROSPACE LTD		Work Order:	144596
Description: Seat Track		Part Number:	D3811-1
Inspection Dwg: D3811		Rev: A	Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

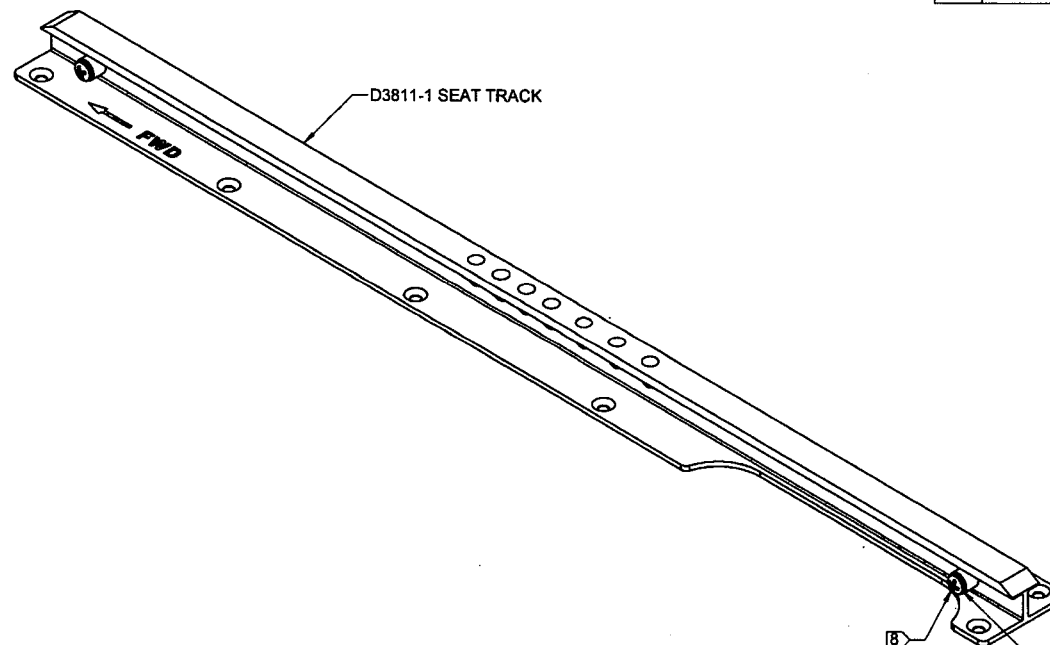
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.120	+/-0.010	.120	✓		SLIO	Veru
0.730	+/-0.010	.730	✓		↓	
0.195	+/-0.010	.194	✓		↓	
0.630	+/-0.010	.630	✓			
	DAS					

Measured by:	9-89 / SK.L.	Audited by:	B.A. DAS 08	Prototype Approval:	N/A
Date:	16-04-25/16-04-05	Date:	16/05/08 9-89	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ	

QTY -041	P/N	DESCRIPTION
X	D3811-041	SEAT TRACK ASSEMBLY
1	D3811-1	SEAT TRACK
4	D3811-3	BUSHING
2	MS21042L3	NUT
2	MS27039-1-15	SCREW



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WITHOUT NOTICE
WORK ORDER

NO. 144596 MJS
10-04-21

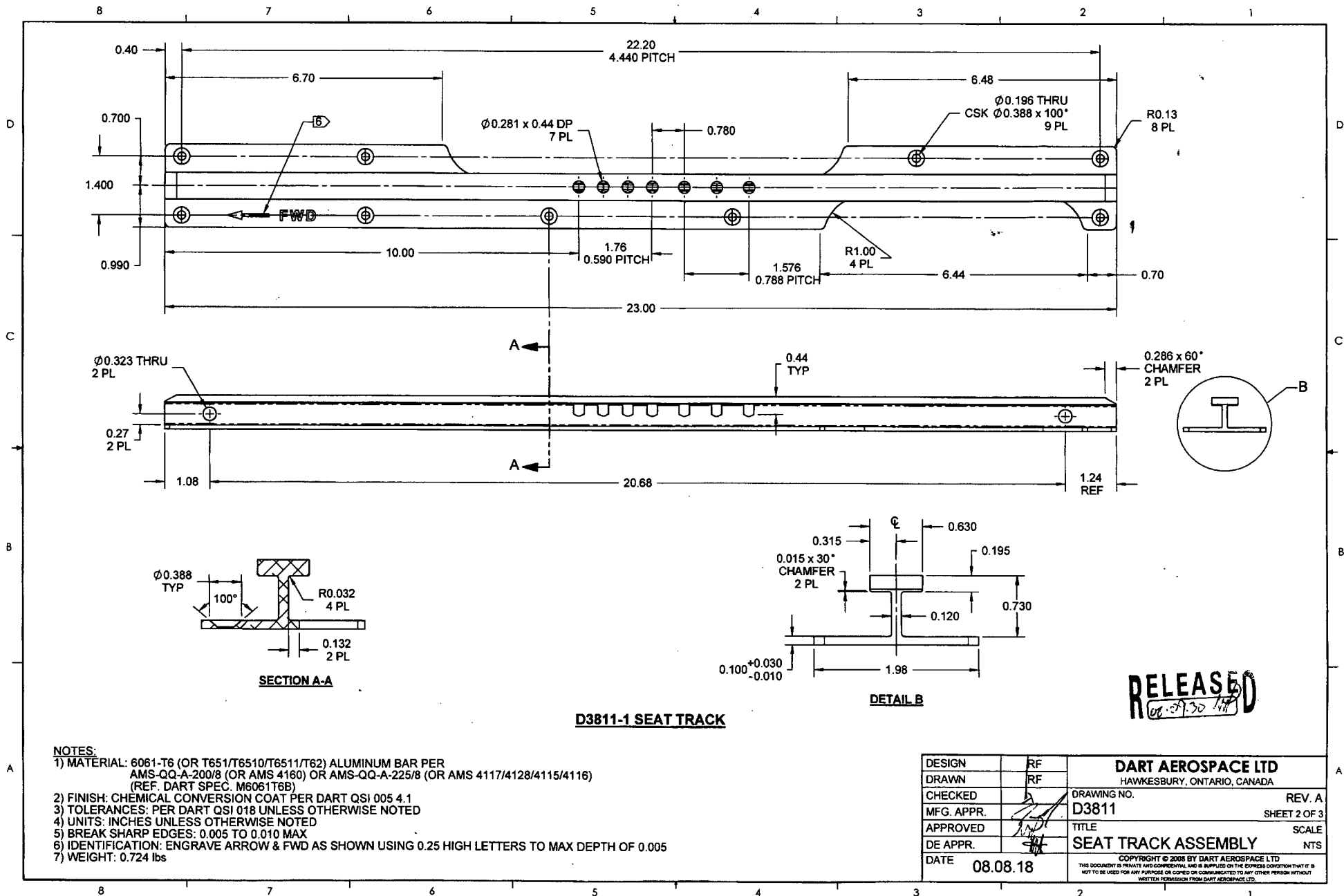
MS27039-1-15 SCREW (1)
MS21042L3 NUT (1)
D3811-3 BUSHING (2)
2 PL

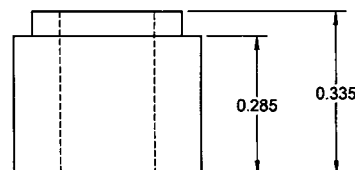
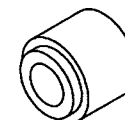
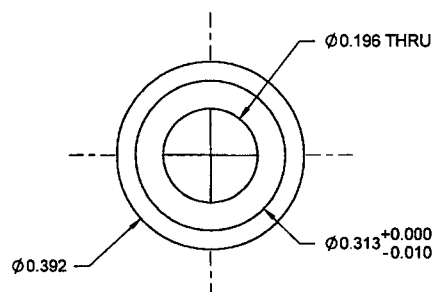
RELEASED
08-08-18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3811-041 & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.76 lbs
- 8) TORQUE FASTENERS TO 20-25 in-lbs

A	NEW ISSUE	RF	08.08.18
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3811	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT TRACK ASSEMBLY	NTS
DATE	08.08.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	





D3811-3 BUSHING

RELEASED
68-04-30/10

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (DART REF. SPEC. M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.003 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3811	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT TRACK ASSEMBLY	NTS
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